

<b>Notice of Allowability</b>	<b>Application No.</b>	<b>Applicant(s)</b>	
	10/648,981	MCCLUNG, JAMES A.	
	<b>Examiner</b>	<b>Art Unit</b>	
	Dmitry Suhol	3725	

**-- The MAILING DATE of this communication appears on the cover sheet with the correspondence address--**

All claims being allowable, PROSECUTION ON THE MERITS IS (OR REMAINS) CLOSED in this application. If not included herewith (or previously mailed), a Notice of Allowance (PTOL-85) or other appropriate communication will be mailed in due course. **THIS NOTICE OF ALLOWABILITY IS NOT A GRANT OF PATENT RIGHTS.** This application is subject to withdrawal from issue at the initiative of the Office or upon petition by the applicant. See 37 CFR 1.313 and MPEP 1308.

1. ☐ This communication is responsive to \_\_\_\_\_.
2. ☒ The allowed claim(s) is/are 1-23.
3. ☐ Acknowledgment is made of a claim for foreign priority under 35 U.S.C. § 119(a)-(d) or (f).
  - a) ☐ All    b) ☐ Some\*    c) ☐ None    of the:
    1. ☐ Certified copies of the priority documents have been received.
    2. ☐ Certified copies of the priority documents have been received in Application No. \_\_\_\_\_.
    3. ☐ Copies of the certified copies of the priority documents have been received in this national stage application from the International Bureau (PCT Rule 17.2(a)).

\* Certified copies not received: \_\_\_\_\_.

Applicant has THREE MONTHS FROM THE "MAILING DATE" of this communication to file a reply complying with the requirements noted below. Failure to timely comply will result in ABANDONMENT of this application.

**THIS THREE-MONTH PERIOD IS NOT EXTENDABLE.**

4. ☐ A SUBSTITUTE OATH OR DECLARATION must be submitted. Note the attached EXAMINER'S AMENDMENT or NOTICE OF INFORMAL PATENT APPLICATION (PTO-152) which gives reason(s) why the oath or declaration is deficient.
  5. ☐ CORRECTED DRAWINGS (as "replacement sheets") must be submitted.
    - (a) ☐ including changes required by the Notice of Draftsperson's Patent Drawing Review (PTO-948) attached
      - 1) ☐ hereto or 2) ☐ to Paper No./Mail Date \_\_\_\_\_.
    - (b) ☐ including changes required by the attached Examiner's Amendment / Comment or in the Office action of Paper No./Mail Date \_\_\_\_\_.
- Identifying indicia such as the application number (see 37 CFR 1.84(c)) should be written on the drawings in the front (not the back) of each sheet. Replacement sheet(s) should be labeled as such in the header according to 37 CFR 1.121(d).
6. ☐ DEPOSIT OF and/or INFORMATION about the deposit of BIOLOGICAL MATERIAL must be submitted. Note the attached Examiner's comment regarding REQUIREMENT FOR THE DEPOSIT OF BIOLOGICAL MATERIAL.

**Attachment(s)**

- |  |   |
|--|---|
| 1. <input checked="" type="checkbox"/> Notice of References Cited (PTO-892)  | 5. <input type="checkbox"/> Notice of Informal Patent Application (PTO-152)           |
| 2. <input checked="" type="checkbox"/> Notice of Draftsperson's Patent Drawing Review (PTO-948)  | 6. <input type="checkbox"/> Interview Summary (PTO-413),<br>Paper No./Mail Date _____ |
| 3. <input checked="" type="checkbox"/> Information Disclosure Statements (PTO-1449 or PTO/SB/08),<br>Paper No./Mail Date <u>8/26/03, 9/27/05</u> | 7. <input type="checkbox"/> Examiner's Amendment/Comment                              |
| 4. <input type="checkbox"/> Examiner's Comment Regarding Requirement for Deposit<br>of Biological Material                                       | 8. <input checked="" type="checkbox"/> Examiner's Statement of Reasons for Allowance  |
|  | 9. <input type="checkbox"/> Other _____   |

*D. Suhol*  
D. Suhol

### REASONS FOR ALLOWANCE

The following is an examiner's statement of reasons for allowance: The specific limitations of (with respect to claim 1) "...a method of forming an annular roller reinforcing rib between a central panel and a chuckwall of an end shell in a single stroke and at a single station of a double action press prior to the removal of the shell from the press...forming the rolled reinforcing rib from an unclamped portion of the chuckwall within the annular void by advancing the inner and outer pressure sleeves while maintaining clamping engagement of the central panel between the punch core and die core, and between the inner pressure sleeve and die core ring...", (with respect to claim 9) "...a method of forming an annular roller reinforcing rib between a central panel and a chuckwall of an end shell in a single stroke and at a single station of a double action press prior to the removal of the shell from the press...forming the rolled reinforcing rib from an unclamped portion of the chuckwall within the annular void by advancing the pressure sleeve while maintaining clamping engagement of the central panel between the punch core and die core, and between the pressure sleeve and die core ring...", (with respect to claim 11) "...a punch core carried by the inner ram and a die core mounted on the base in opposed relationship therewith...inner and outer pressure sleeves carried by the outer ram and a movable die core ring carried by the base in opposed relationship therewith...said outer pressure sleeve releasably holding an outer flange of the blank against the die core ring as the die core draws material over the die core ring to form a chuckwall extending between said outer flange and a central panel...said inner pressure sleeve being movable into clamping engagement with and

Art Unit: 3725

holding a portion of the chuckwall adjacent the outer flange against the die core ring leaving an unclamped portion of the chuckwall extending between the central panel and clamped portion of said chuckwall...said inner and outer pressure sleeves being movable toward the base while maintaining clamping engagement of the chuckwall and the outer flange against the inner die core ring to roll the unclamped portion of the chuckwall into the rolled reinforcing rib...said punch core and inner and outer pressure sleeves being simultaneously movably out of clamping engagement with the central panel, chuckwall, and outer flange to retain the shape of the rolled reinforcing rib...”, and (with respect to claim 15) “...a timing control which simultaneously retracts said punch core and said inner and outer pressure sleeves with respect to said punch core and die core ring after said punch core and said inner and outer pressure sleeves have reached a bottom-dead-center position” are not anticipated or made obvious over the prior art of record in the examiners opinion. For example, Zysset '721 discloses a method and apparatus for manufacturing container ends which teaches folding/rolling a portion of a chuckwall (figure 8) by a first (76) and second dies (78), however Zysset's method steps are performed through multiple operations at a variety of press stations. Additionally, Zysset fails to teach the apparatus as claimed including inner and outer pressure sleeves, die core ring, etc. It should further be noted that since applicants have referred to “the rolled reinforcing rib” (claims 1 and 9), such language effectively breaths life into the preamble and thus the limitation of “...a single stroke and at a single station of a double action press prior to the removal of the shell from the press...” has been given patentable weight.

Art Unit: 3725

Any comments considered necessary by applicant must be submitted no later than the payment of the issue fee and, to avoid processing delays, should preferably accompany the issue fee. Such submissions should be clearly labeled "Comments on Statement of Reasons for Allowance."

### ***Conclusion***

Any inquiry concerning this communication or earlier communications from the examiner should be directed to Dmitry Suhol whose telephone number is 571-272-4430. The examiner can normally be reached on Mon - Friday 8:30am-5:00pm.

If attempts to reach the examiner by telephone are unsuccessful, the examiner's supervisor, Derris Banks can be reached on (571) 272-4419. The fax phone number for the organization where this application or proceeding is assigned is 571-273-8300.

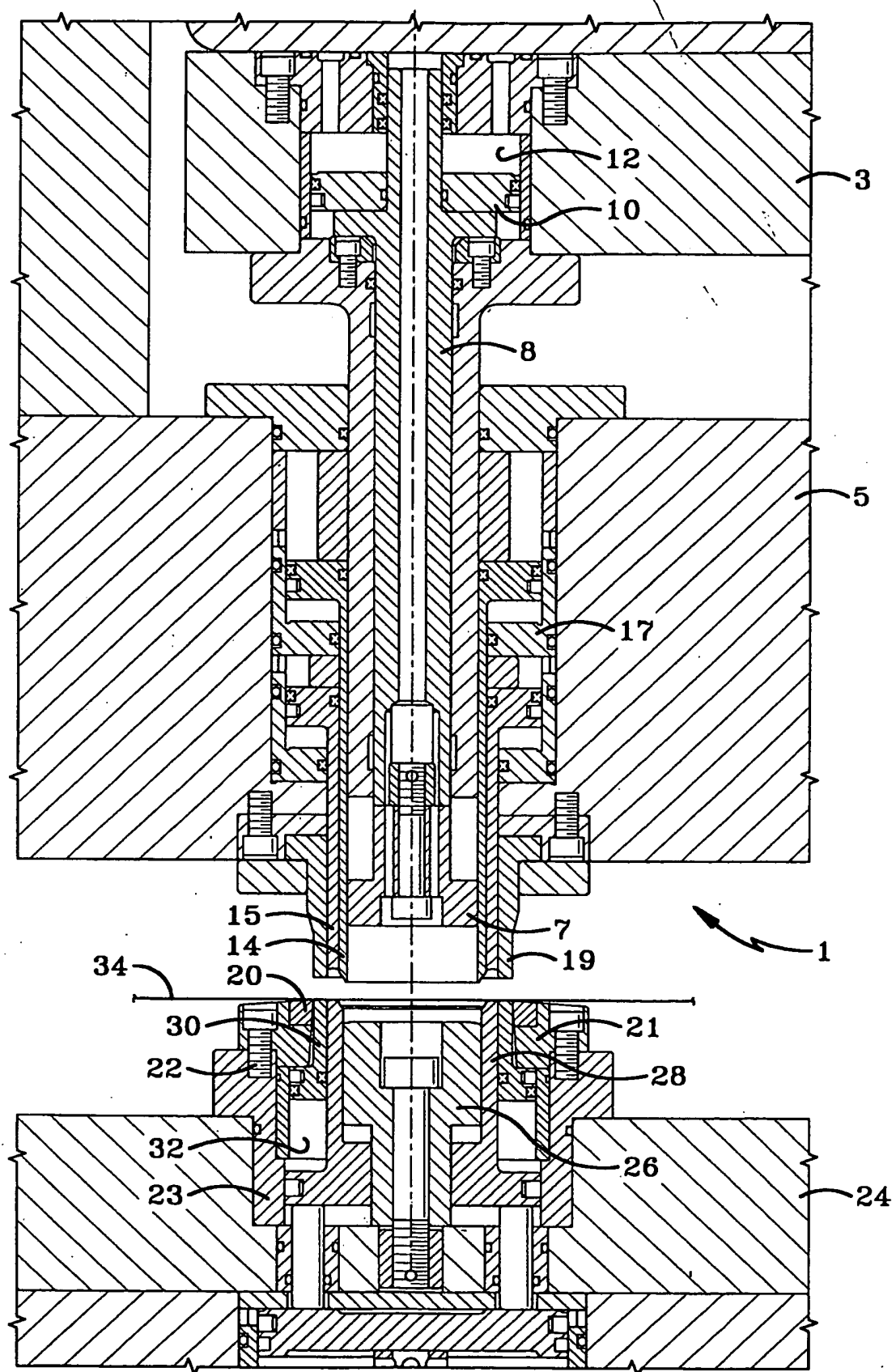
Information regarding the status of an application may be obtained from the Patent Application Information Retrieval (PAIR) system. Status information for published applications may be obtained from either Private PAIR or Public PAIR. Status information for unpublished applications is available through Private PAIR only. For more information about the PAIR system, see <http://pair-direct.uspto.gov>. Should you have questions on access to the Private PAIR system, contact the Electronic Business Center (EBC) at 866-217-9197 (toll-free).



Dmitry Suhol  
Examiner  
Art Unit 3725

ds





**FIG-1**

72/348

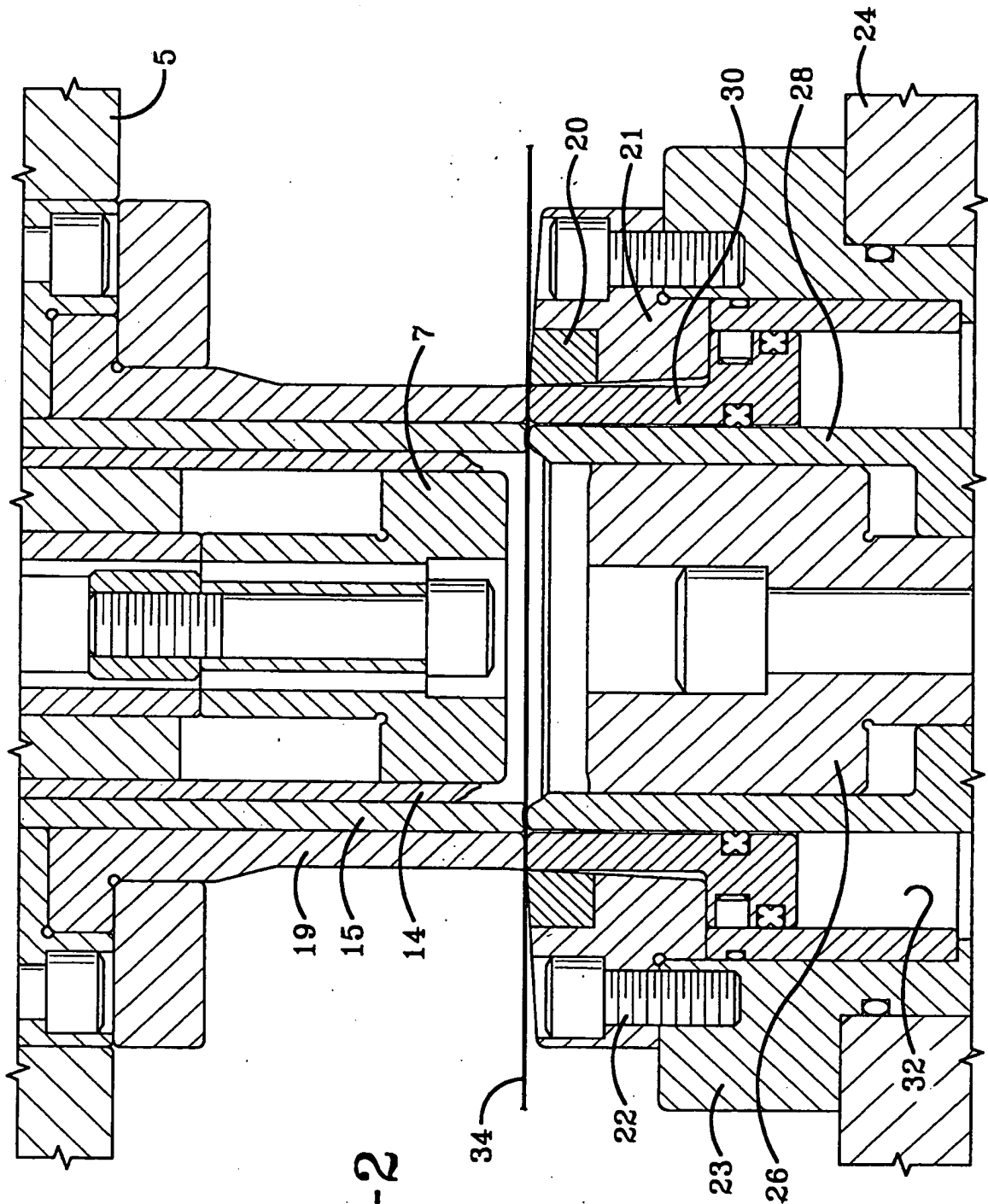


FIG-2

72/348

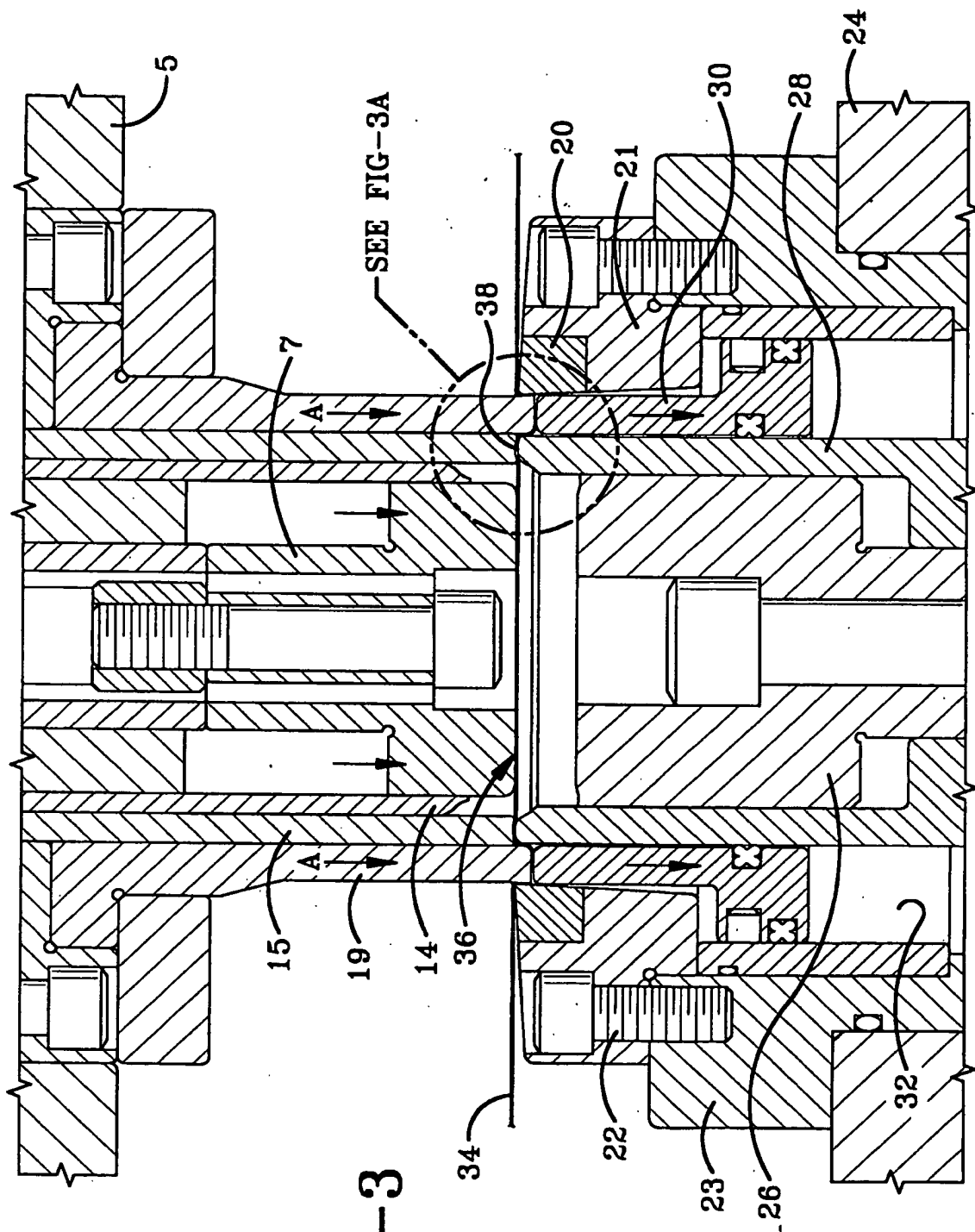


FIG-3



**FIG-3A**

[illegible]

---

11

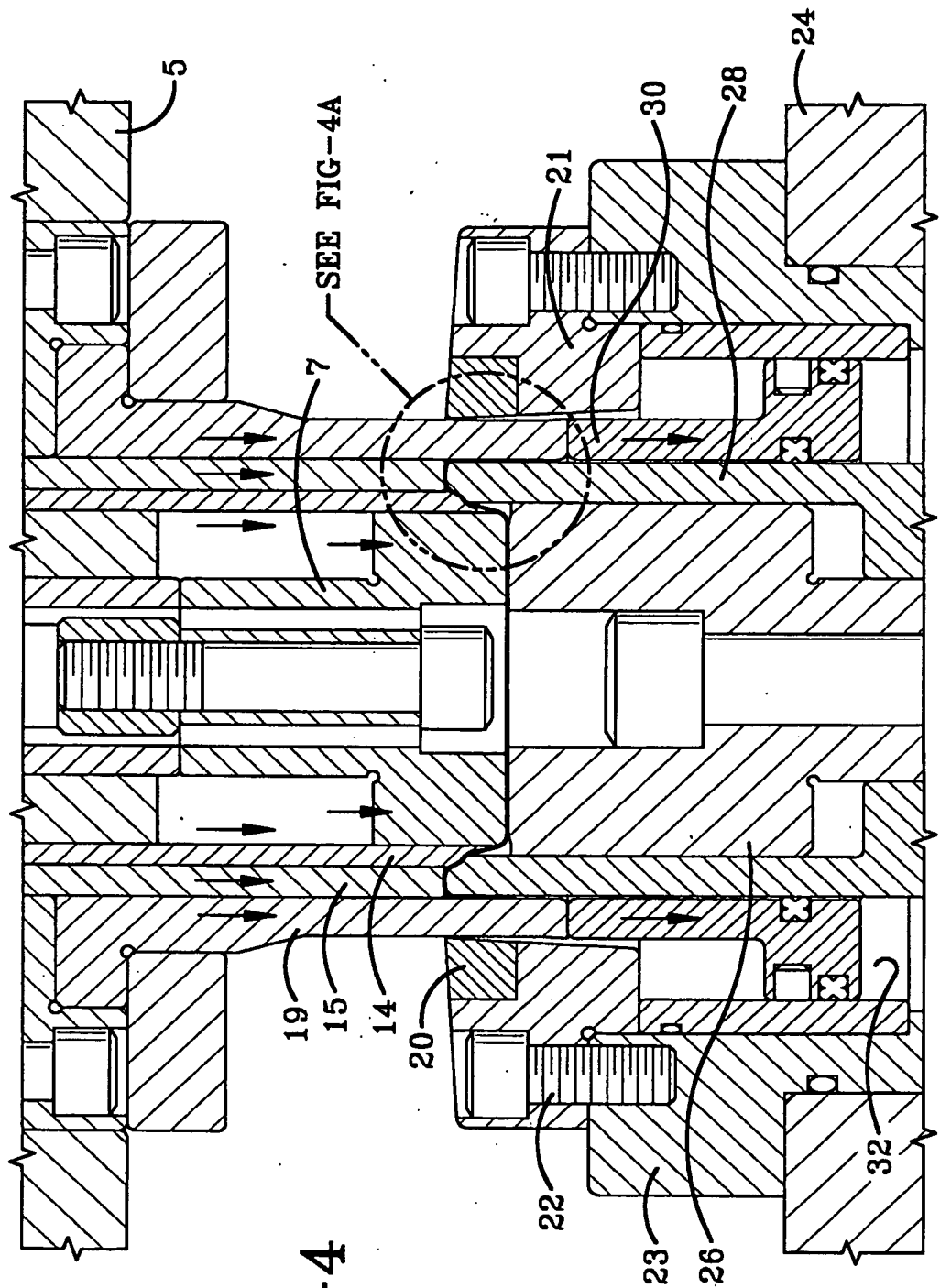


FIG-4

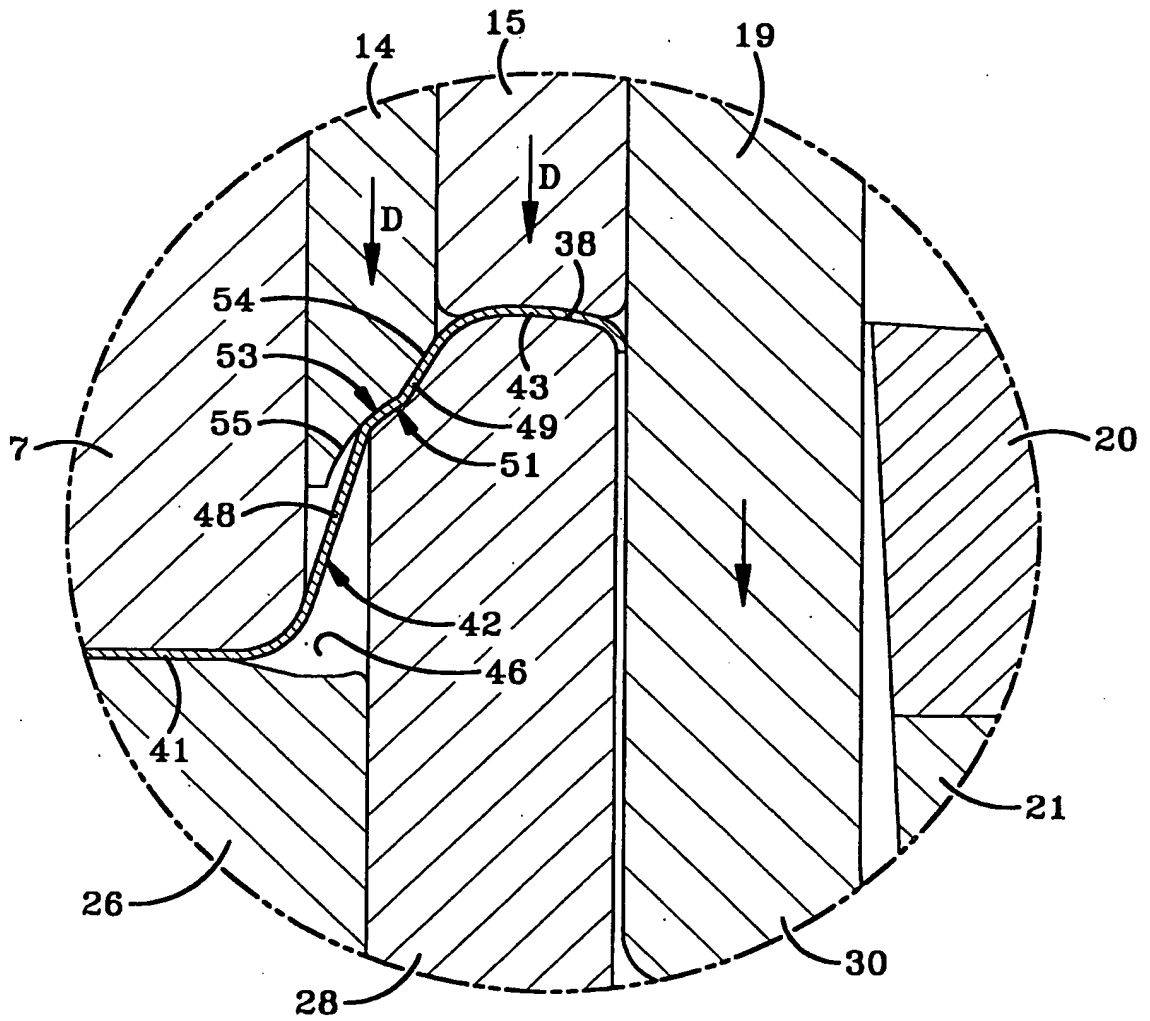


FIG-4A

72/348

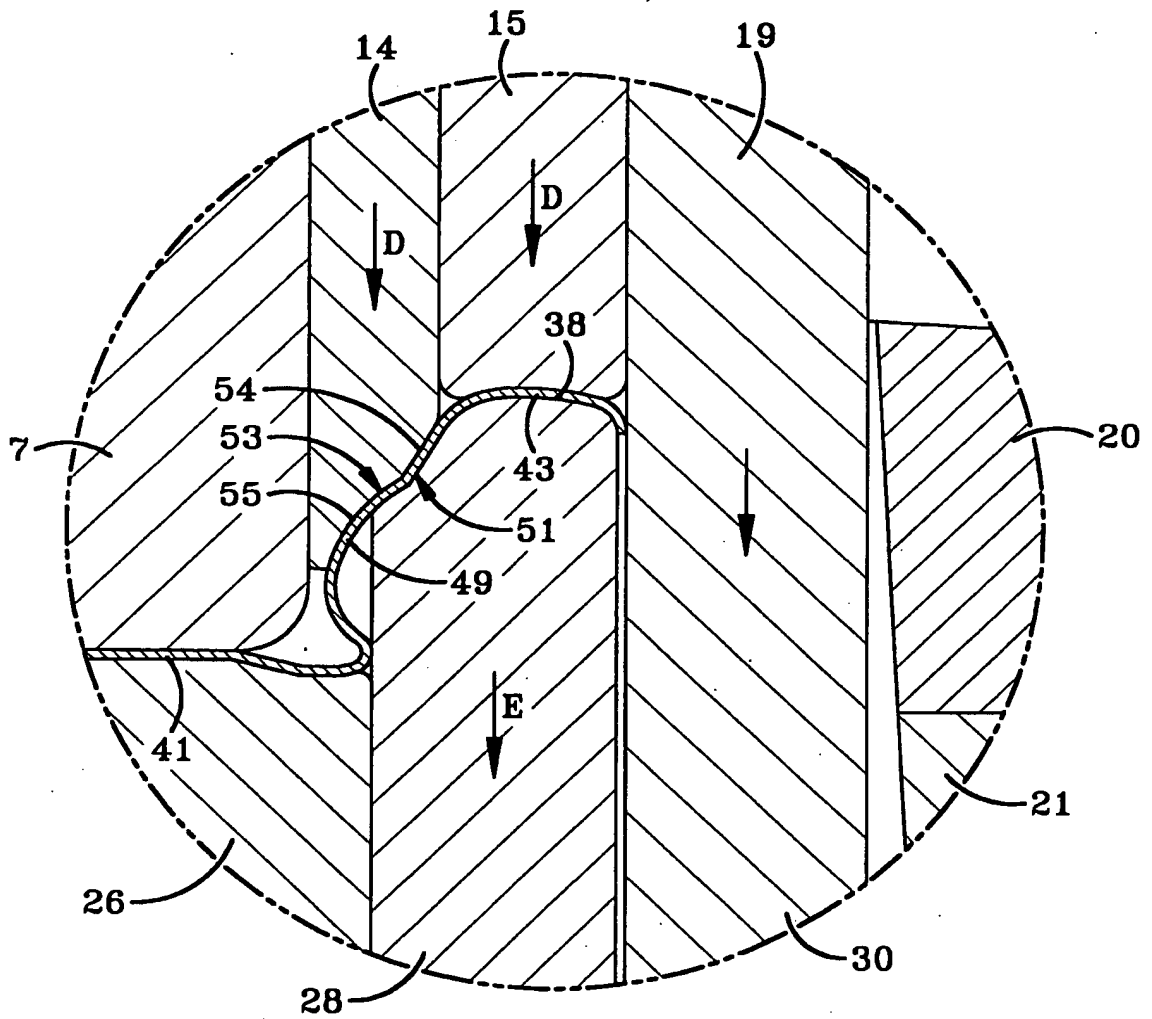


FIG-4B

72/348

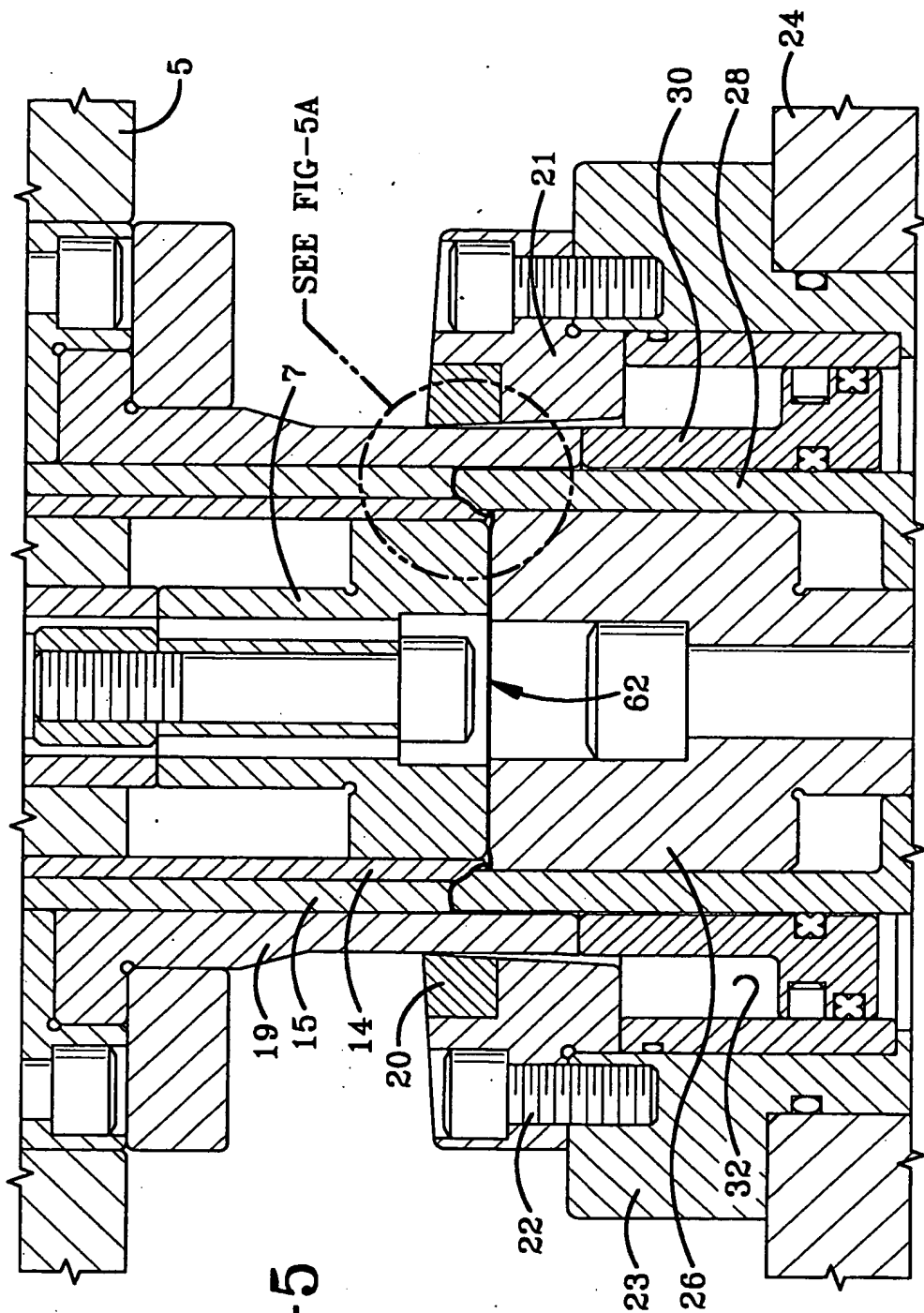


FIG-5

72/348

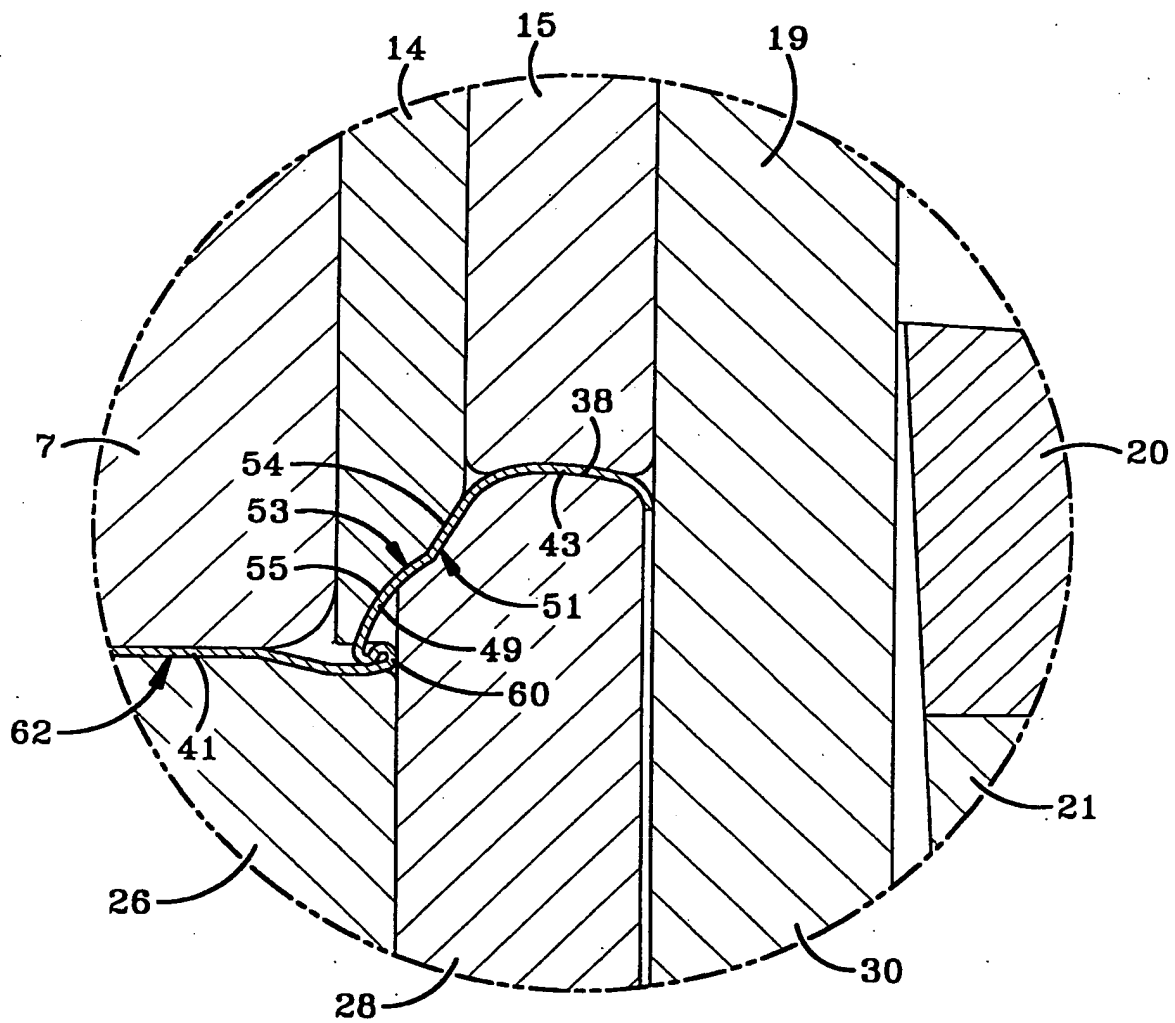


FIG-5A



72/348

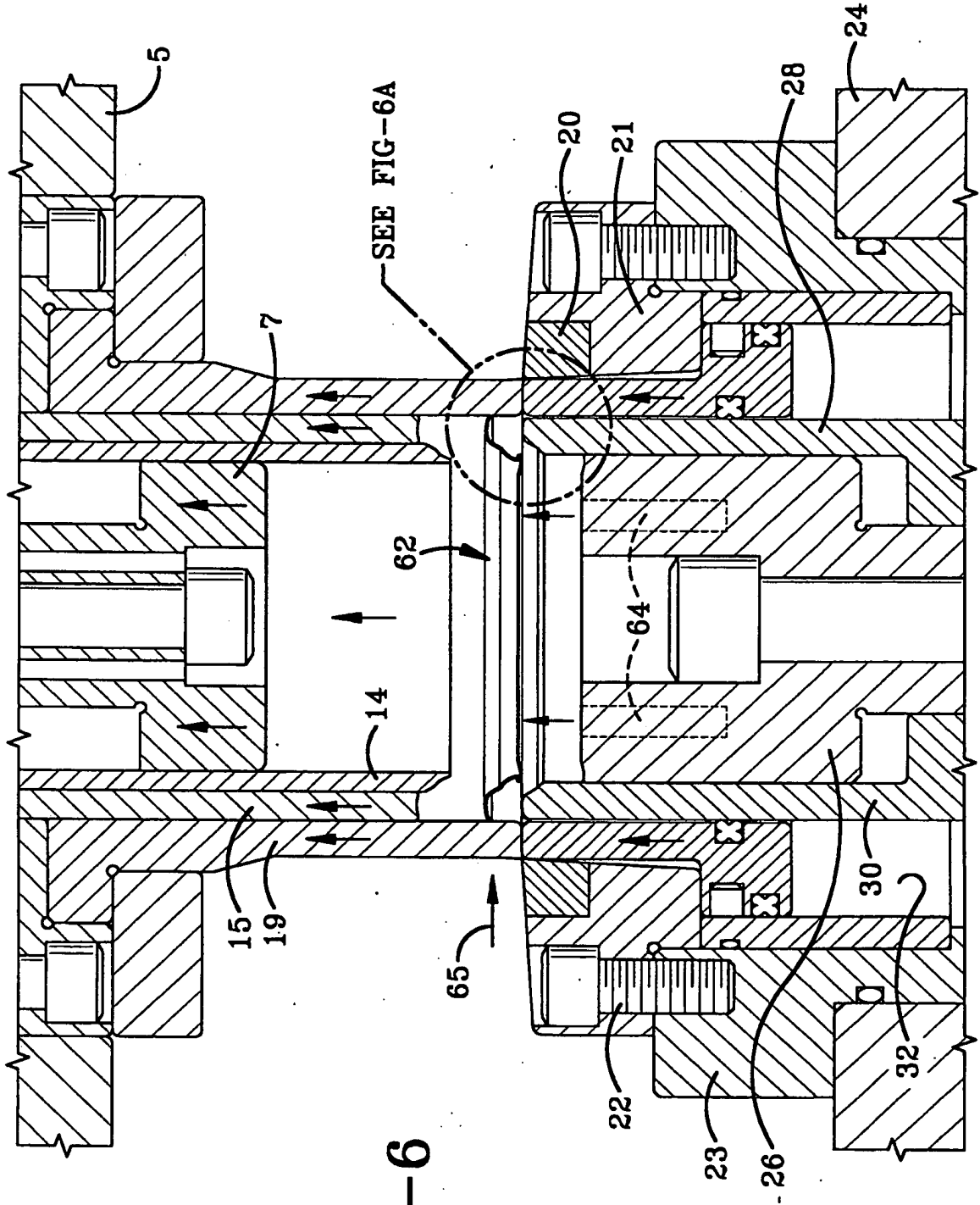


FIG-6

SEE FIG-6A

**FIG-5B**

72/348

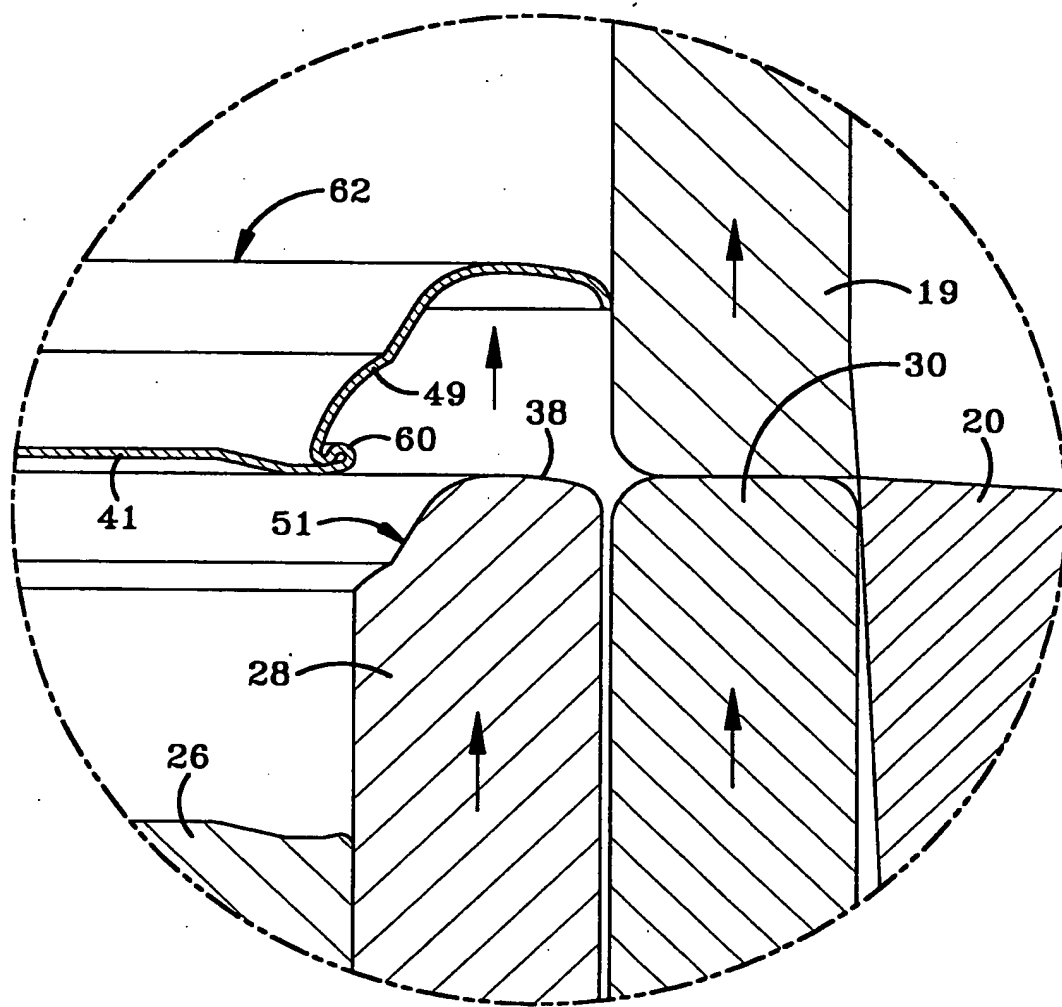


FIG-6A

72/348

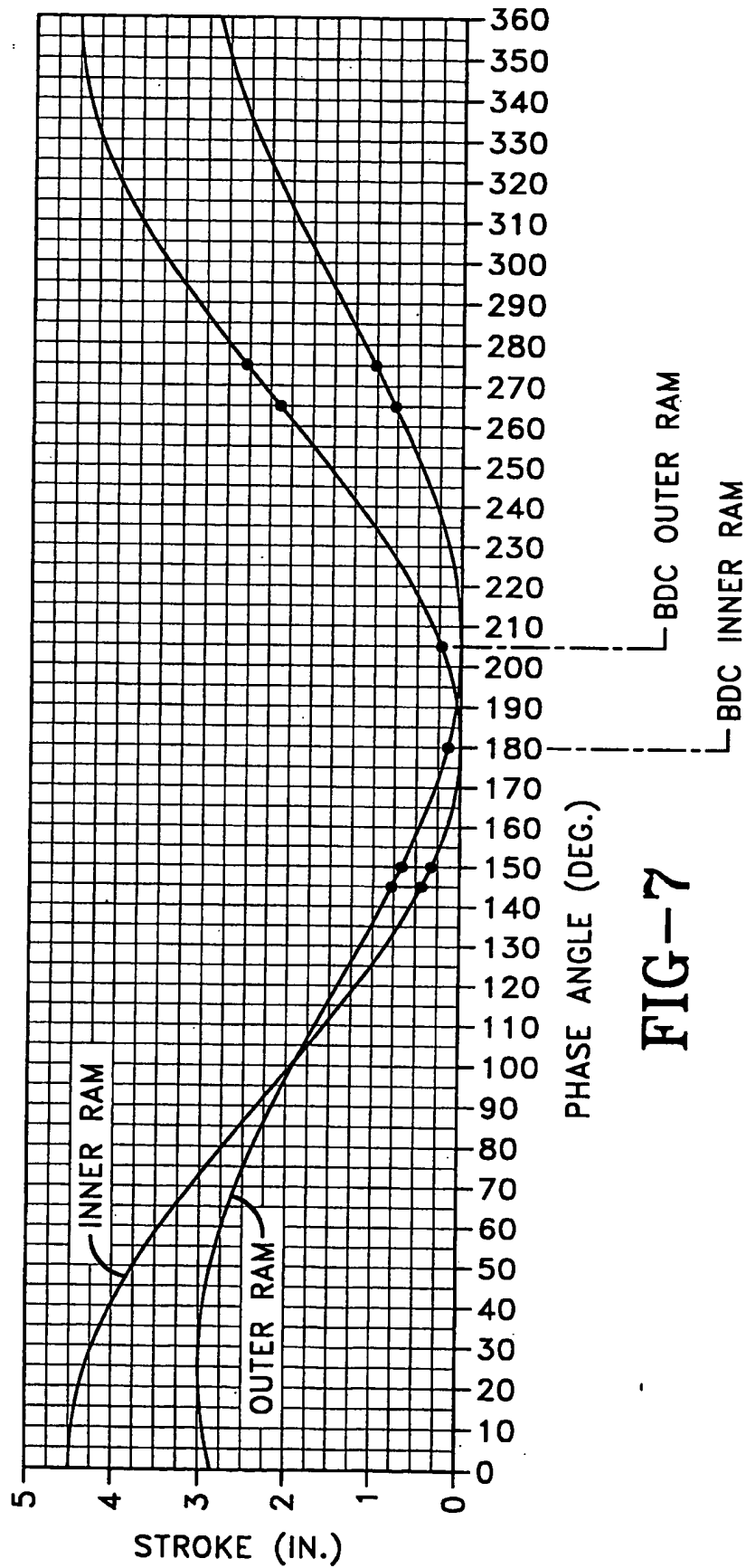


FIG--7

72/348

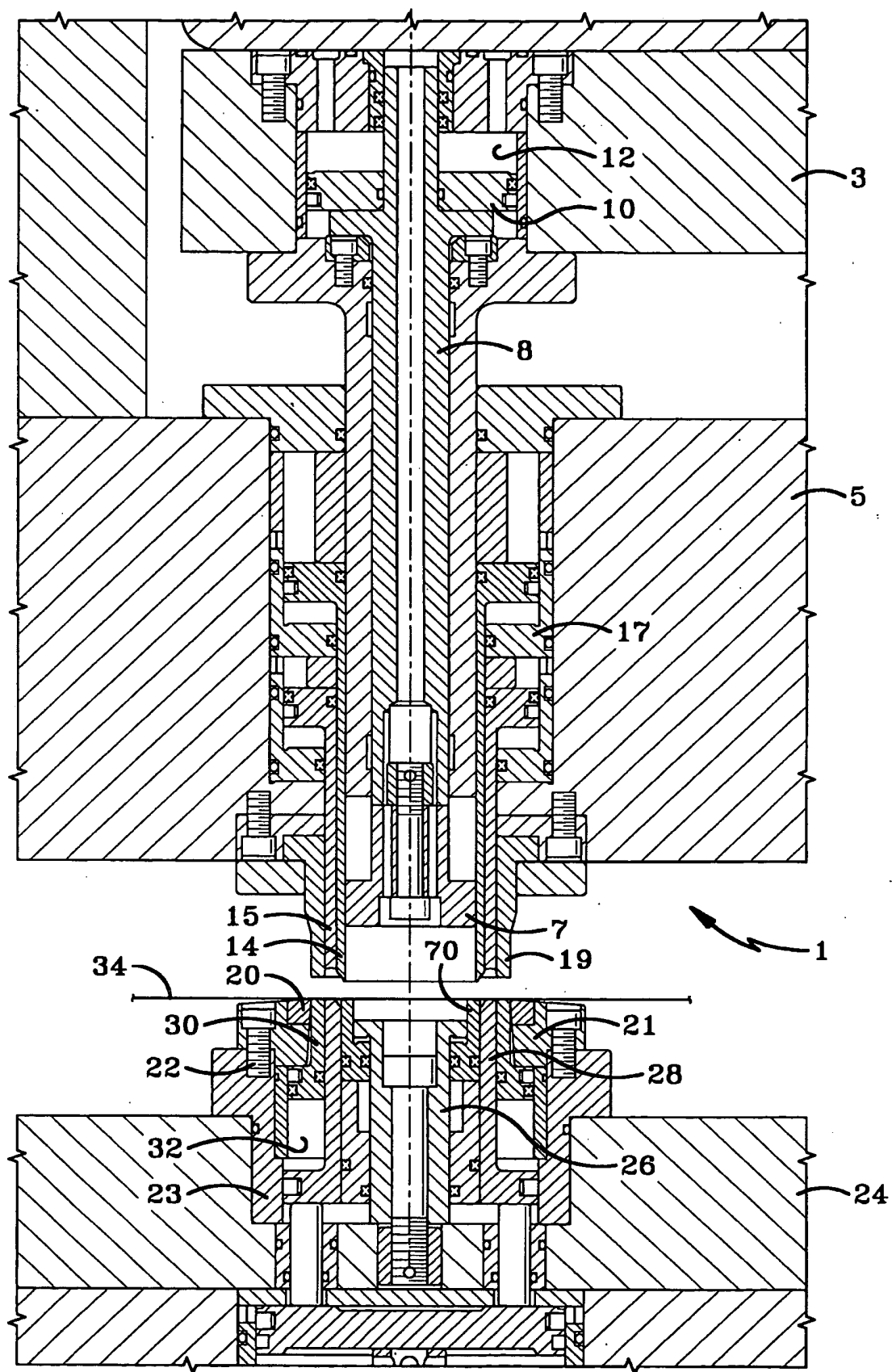


FIG-8